Work Order ID 117333

Monday, June 16, 2014 11:30:26 AM

117333

Item ID: D4884-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: End Fitting, Eye **Stop** *NS2*

Start Date: 6/16/14 **Start Qty:** 5.00 *5*

Required Date: 6/20/14 **Req'd Qty:** 5.00 *5*

Cust Item ID:

Customer:

Reference: Part sent for marking – Rework

Approvals: **Process Plan:** [signature] **Date:** 14-6-16 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4884	REV A								
105		0.00							
105									
Purchasing									
Purchasing	**Memo**	0.00							
	PULL FROM STOCK D4884-3 (X5) B111342 (X2) ✓ B112031 (X3) ✓								
	PART SENT TO P&L FOR MARKING								
115	Receive & Inspect for Damage & Mat'l Certs	0.00							
115									
Packaging									
Packaging	**Memo**	0.00							

u 14-66-16
P/O: 24622

CL 14/06/17

5/4/6/18 (S)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4884-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: End Fitting, Eye
Start Date: 6/16/14 **Start Qty:** 5.00 *5*
Required Date: 6/20/14 **Req'd Qty:** 5.00 *5*
Reference: Part sent for marking
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC6- Inspect dimensions to drawing	0.00				5			
125 QC Quality Control	**Memo**	0.00							
135		0.00							
135 Packaging Packaging	**Memo** REPACKAGE USING NEW B/N	0.00					14/6/20		
145	QC21- Final Inspection - Work Order Release	0.00							
145 QC Quality Control	**Memo**	0.00					14/6/23		

DAS 27 9-89

14/6/20

st 125

14-6-20

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

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Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

Picklist Print

Monday, June 16, 2014 11:30:32 AM

Work Order ID: 117333

117333

Parent Item: D4884-3

D4884-3

Parent Item Name: End Fitting, Eye

Start Date: 6/16/14 **Required Date:** 6/20/14

Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4884-3		Manufactured	No				Each	0.0000		5			
D4884-3 End Fitting, Eye									**				

111342 X2
112031 X3 14-6-16

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Turning Sequence
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General

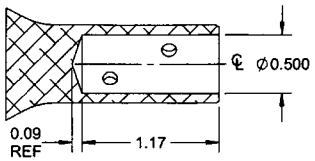
☐ Bend
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☐ Cut Too Short
☐ Drawing
☐ Drill Holes
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☐ Out of Sequence

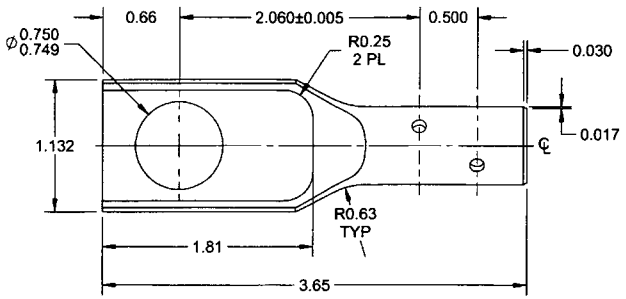
☐ Outside Dimensions
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☐ Weld
☐ Wrong Stock Pulled

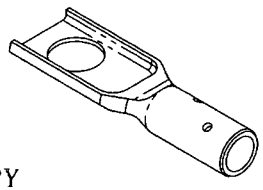
☐ Other _____

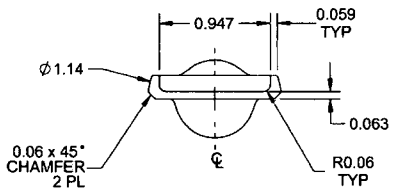


SECTION B-B C5-1

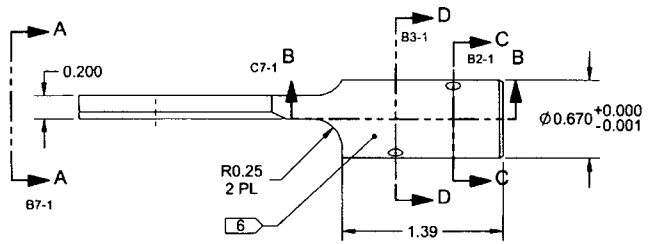


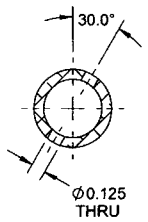
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 117333NP
11-6-16



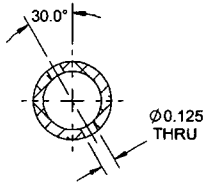


VIEW A-A B6-1





SECTION C-C C4-1



SECTION D-D C5-1

D4884-1 END FITTING, EYE

RELEASED
2013-12-12

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.13 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	13.09.16

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4884 REV. A
MFG. APPR.	JLM	SHEET 1 OF 2
APPROVED	HS	TITLE END FITTING SCALE NTS
DE APPR.	DS	
DATE	13.12.01	

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CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

P.O NUMBER PO24622

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4880-042 LEG ASSEMBLY	1	ALL ITEMS HAVE BEEN LASER MARKED
D4881-041 LEG ASSEMBLY	1	
D4881-042 LEG ASSEMBLY	1	
D4882-041 LEG ASSEMBLY	2	
D4880-041 LEG ASSEMBLY	1	
D4803-1 STRUT	1	
D4871-3 END FITTING EYE	11	
D4866-2 STRUT	2	
D4882-1 STRUT	3	
D4866-1 STRUT	2	
D4928-1 STRUT	4	
D4807-041 SUPPORT ASSEMBLY	2	
D4878-1 STRUT	1	
D4867-1 STRUT	4	
D4868-1 STRUT	4	
D4884-1 END FITTING EYE	8	
D4884-3 END FITTING EYE	5	
D4801-1 STRUT	1	
D4804-1 STRUT	2	
D4806-1 CLEVIS	2	
D4806-3 STUD	8	
D4879-1 STRUT	2	

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CANADA

SHIPPED TO
DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

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ITEM DESCRIPTION	QUANTITY	COMMENTS
D4880-042 LEG ASSEMBLY	1	ALL ITEMS HAVE BEEN LASER MARKED
D4881-041 LEG ASSEMBLY	1	
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D4882-041 LEG ASSEMBLY	2	
D4880-041 LEG ASSEMBLY	1	
D4803-1 STRUT	1	
D4871-3 END FITTING EYE	11	
D4866-2 STRUT	2	
D4882-1 STRUT	3	
D4866-1 STRUT	2	
D4928-1 STRUT	4	
D4807-041 SUPPORT ASSEMBLY	2	
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D4867-1 STRUT	4	
D4868-1 STRUT	4	
D4884-1 END FITTING EYE	8	
D4884-3 END FITTING EYE	5	
D4801-1 STRUT	1	
D4804-1 STRUT	2	
D4806-1 CLEVIS	2	
D4806-3 STUD	8	
D4879-1 STRUT	2	